



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBEM651V3000121-1
Job Sheet 181891



Part No: RBEM651V3000121-1

Job Qty: 8 ea

Part Name: Collar



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 8/10/18

Job Tracking No:

Due Date: 8/20/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM651V3000121 Rev. 2 IPP Rev. A 18.06.29 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	8/20/18	8/20/18	0.00	0.00	Start Up Machining-4		SL
120	CNC Lathe	8 pcs	8/20/18	8/20/18	0.00	0.00	MORI SL2500Y		SL
130	QC	8 pcs	8/20/18	8/20/18	0.00	0.00	QC2 Machining-5		SL
150	Mill Conv	8 pcs	8/20/18	8/20/18	0.25	4.00	Mill Conv 2		SL
155	QC	8 pcs	8/20/18	8/20/18	0.00	0.00	QC2 Machining-5		SL
160	QC	8 pcs	8/20/18	8/20/18	0.00	0.00	QC8 Machining-5		SL
161	Small Fab	8 pcs	8/20/18	8/20/18	0.00	0.80	Small Fab-1		SL
162	QC	8 pcs	8/20/18	8/20/18	0.00	0.00	QC5		SL
170	Packaging	8 pcs	8/20/18	8/20/18	0.00	0.00	Packaging3-2		SL
180	QC21-SA	8 Ea	8/20/18	8/20/18	0.00	0.00	QC21		SL

Part Op 120 - Cut blanks to 3.88". 1-Machine as per folio FC194 FOLIO REV: AA DWG REV: 2 2-Deburr
 Descriptions: 150 - 1-Machine as per DWG. 2-Deburr 3-Fixture on rack A right side
 161 - Fill engraving with paint
 170 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINR6.000W	M-Delrin Round Bar, White	2.5840 pcs (.323 ea)	90-Start up Operation	5091253

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELINR6.000W	3	6	0



Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

be found.

Plex 10/1/18 4:16 PM dart.logan.david

Container No: S115412



Part: RBEM651V3000121-1

Job No: 181891

Serial No/Batch: S115412

Revision: 2

Inspector:

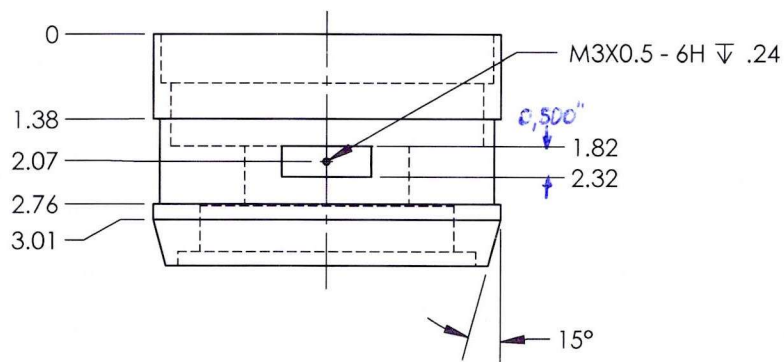
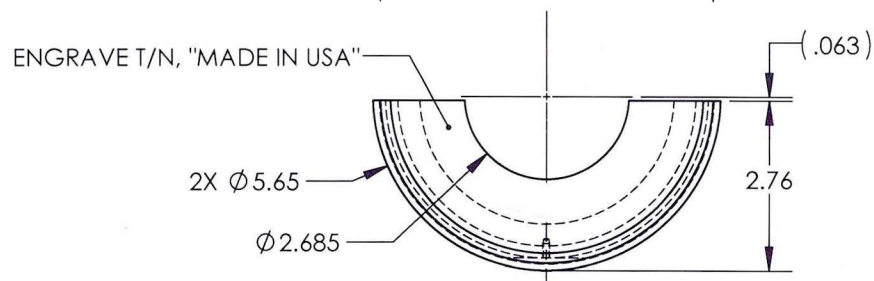
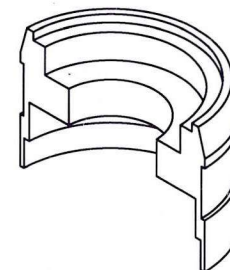
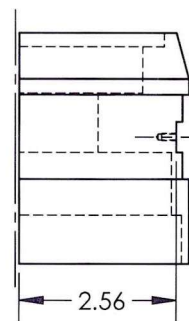
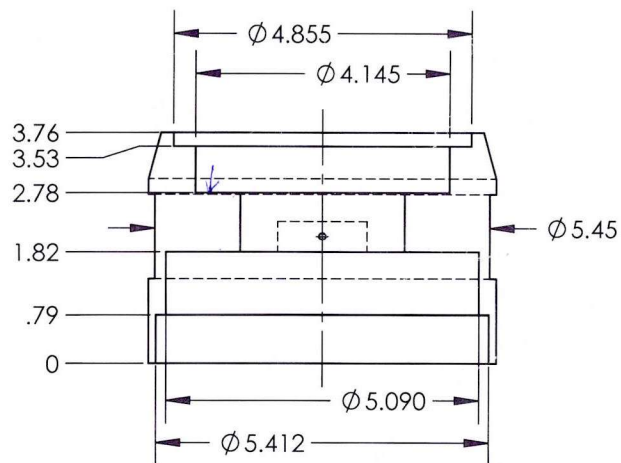
Exp Date:

Instructions:

Date: 10/03/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0209	-1 CH'D DIM'S WAS .017 ±.010 IS (.063), WAS 2.81 IS 2.76, WAS 2.61 IS 2.56, WAS M3X0.5 -6H ▽.24 IS M3X0.5 -6H ▽.24.	11/2/2016	RJC	JAG



(1)
COLLAR

DART AEROSPACE	
TITLE FRONT SHAFT PROTECTOR	
DWG NO. RBEM651V3000121-1	REV 2
MAT'L DELRIN/ACETRON GP	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES 015 x 45° OR 015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:3	DATE 4/21/2016
SHEET 2 OF 7	

DART AEROSPACE LTD		Work Order:
Description: FRONT SHAFT PROTECTOR		Part Number: RBEM651V3000121-1
Inspection Dwg: RBEM651V3000121-1 Rev: 2		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.855	±.005	4.854	/			
4.145	±.005	4.144	/			
5.45	±.01	5.448	/			
5.090	±.005	5.09	/			
5.412	±.005	5.412	/			
.79	±.01	.789	/			
1.82	±.01	1.82	/			
2.78	±.01	2.783	/			
3.53	±.01	3.532	/			
3.76	±.01	3.762	/			
5.65	±.01	5.649	/			
2.685	±.005	2.685	/			
1.38	±.005	1.384	/			
2.76	±.01	2.761	/			
3.01	±.01	3.01	/			
15°	±.5°	15°	/			
2.76	±0.010	2.765	/			
2.56	"	2.560	/			
1.82	"	1.822	/			
2.32	"	2.318	/			
2.07	"	2.070	/			
M3x0.5	60 / 10.00	M3x0.5	/			
0.24	±0.010	0.250	/			

Measured by: SL / 18/10/4	Checked by: D.C.	QC Inspector:
Date: 18-10-3	Date: 18-10-07	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other	AGAINST DEPARTMENT/PROCESS																																																																																																																									
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